

Amendment to the Claims

This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

1-13. (Cancelled)

14. (previously presented) A method of forming a plurality of perforations in a concavely curved domed portion of a vent disc, said plurality of perforations each having centerlines, which comprises:

forming said plurality of perforations with each of said centerlines coincident to a radius that forms a concave curvature of said domed portion,

wherein said plurality of perforations have at least two different diameters through said domed portion,

wherein said plurality of perforations are resealable, and wherein said domed portion is elastomeric.

15. (currently amended) The method of claim 14, further comprising forming a plurality of upwardly extending depressions in an undersurface of said domed portion, said plurality of depressions each having a centerline that is coincident with said radius that forms said concave curvature of ~~a~~ said domed portion.

16. (currently amended) A method of forming a plurality of perforations in a concavely curved domed portion of a vent disc,

which comprises:

forming a plurality of upwardly extending depressions in an undersurface of said domed portion while leaving a residual of said domed portion above said plurality of depressions, said plurality of depressions each having a centerline, each of said centerlines being coincident with a radius that forms a concave curvature of said domed portion; and

forming a plurality of perforations through said residual, said plurality of perforations being resealable and each having a centerline, each of said centerlines of said plurality of perforations being formed coincident to a corresponding said centerlines of one of said plurality of depressions, wherein said domed portion is elastomeric.

17. (withdrawn) Apparatus for forming a plurality of perforations in a concavely curved domed portion of a vent disc, which comprises:

a plurality of elongated means for piercing the domed portion of the vent disc to form the plurality of perforations, each of said plurality of piercing means having a longitudinal central axis;

means for mounting said plurality of piercing means so that their central axes are coincident with the radii of curvature that form the domed portion of the vent disc;

means for holding the domed portion; and

means for driving said piercing means along said radii of curvature and through the domed portion of the vent disc to form the plurality of perforations.

18. (previously presented) The method of claim 14, wherein said perforations that are formed have slits with a width about 0.040 to about 0.080 inches.

19. (previously presented) The method of claim 18, wherein said slits have a width about 0.058 to about 0.062 inches.

20. (previously presented) The method of claim 19, wherein said slits have a width about 0.060 inch.

21. (withdrawn) The method of claim 18, wherein said forming step is effected by piercing said domed portion of said vent disc with blades that have an elongated cutting edge formed by angular surfaces.

22. (withdrawn) The method of claim 21, wherein said angular surfaces are disposed at an angle of about 40 degrees.

23. (withdrawn) The method of claim 21, wherein said forming step is effected by driving said blades completely through said domed portion of said vent disc.

24. (previously presented) The method of claim 16, wherein said perforations that are formed are slits that have a width about 0.040 to about 0.080 inches.

25. (previously presented) The method of claim 24, wherein said slits have a width about 0.058 to about 0.062 inches.

26. (previously presented) The method of claim 25, wherein said slits have a width about 0.060 inch.

27. (withdrawn) The method of claim 24, wherein said forming step is effected by piercing said domed portion of said vent disc with blades that have an elongated cutting edge formed by angular surfaces.

28. (withdrawn) The method of claim 27, wherein said angular surfaces are disposed at an angle of about 40 degrees.

29. (withdrawn) The method of claim 27, wherein said forming step is effected by driving said blades completely through said residual of said domed portion of said vent disc.

30. (withdrawn) The apparatus of claim 17, wherein said means for mounting said plurality of piercing means includes a mandrel having a convex arcuate upper surface with a radii of curvature that corresponds to said radii of curvature that form said domed portion of said vent disc.

31. (withdrawn) The apparatus of claim 30, wherein each of said plurality of piercing means has a base, and wherein said base rests on said arcuate upper surface of said means for mounting.

32. (withdrawn) The apparatus of claim 30, wherein said means for mounting said plurality of piercing means includes a piercing die that is disposed above said mandrel and that has a plurality of elongated slots that extend therethrough for receiving said piercing means, said slots having their longitudinal axes disposed along said radii of curvature that form said arcuate upper surface of said mounting means and along said radii of curvature that form said concavely domed portion

of said vent disc.

33. (withdrawn) The apparatus of claim 32, wherein said driving means drives said means for mounting with said piercing means mounted thereon such that said piercing means are received in said plurality of elongated slots.

34. (withdrawn) The apparatus of claim 32, wherein said piercing die has a convex upper surface with a radii of curvature that corresponds to said radii of curvature of said concavely domed portion of said vent disc.

35. (withdrawn) The apparatus of claim 17, wherein said apparatus includes a backstop, said backstop having an undersurface that is convex and has a radii of curvature that corresponds to said concavely curved domed portion of said central panel.

36. (withdrawn) The apparatus of claim 35, wherein said means for mounting said plurality of piercing means includes a piercing die that is disposed above said mandrel and that has a plurality of elongated slots that extend therethrough for receiving said piercing means, and wherein said holding means includes said undersurface of said backstop and said undersurface has a plurality of relieves formed therein that are radially aligned with said slots in said piercing die.

37. (withdrawn) A method of forming a vent disc having a concavely domed central panel, comprising:

providing vertically reciprocable piercing elements;

providing a vent disc having a concavely domed central panel that is formed by radii of curvature;

temporarily flattening said domed central panel;

disposing said piercing elements such that they are perpendicular to said temporarily flattened domed central panel;

perforating said temporarily flattened domed central panel by use of said vertically reciprocable piercing elements;

removing said piercing elements from said temporarily flattened domed central panel; and

terminating said flattening step to allow said central panel to return to its domed configuration.

38. (withdrawn) The method of claim 37, wherein said perforating step is effected by driving a portion of each of said piercing elements completely through said temporarily flattened domed central panel.

39. (withdrawn) The method of claim 37, wherein said piercing elements are blades that have an elongated cutting edge and said perforating step forms slits in said temporarily flattened domed central panel.

40. (withdrawn) The method of claim 37, wherein said domed central panel has an undersurface and said flattening step is effected by pulling a vacuum against the undersurface of said domed central panel.